

Work Order ID 81394

81394

March-14-12 7:46:33 AM

Page 1

Item ID: D350-636-011

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 13/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 12/03/14 Tooling:

Date:



QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								
100		0.00							

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

JF CL 12-4-9

Z. Saylor

81394

Dart Aerospace Ltd

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81394

March-14-12 7:46:33 AM

81394

Page 2

Item ID: D350-636-011

Accept

N900040100

Setup

Start

NS1

Revision ID:

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Start Date: 13/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

110

Skidtubes

Skidtubes

0.00

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

3/20 14-03-20

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 27/03/2012 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: <i>M20164</i>	→ <i>86 12/03/22</i>							
121	12-Grind welds flush as per Dwg D2750	→ <i>CF 12-3-22</i>							

120
120
QC
Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

PJL 12-03-22

1x P

130
130
QC
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

DP

12-3-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 81394***81394***

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Page 4

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NS1

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Start Date: 13/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

JK 12-3-22

150

150

QC

Quality Control

QC3- Inspect Part Finish

0.00

QC7

Memo

0.00

DP 12-3-22

W/O:		WORK ORDER CHANGES					
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Page 5

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NS2**Start Date:** 13/03/2012 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 27/03/2012 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:****Run**

Start

NR1**QC:****Date:****SPC (Y/N):****Date:**

Stop

NR2**Sequence ID/
Work Center ID**

160

160

Skidtubes

**Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

Skidtubes

0.00

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015

A/R Sikaflex-291

batch: M120813

exp. date: 12-08-13

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod batch: M120164

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

3B 12/03/22

TK - 123-22

3B 12-03-24
→ CF 12.3.26

W/O:		WORK ORDER CHANGES					
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March 14 2012 7:46:33 AM

81394

Page 6

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1

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1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

CC 12/3/26

BB

12-Deburr holes

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

5/2/3/27

Memo

0.00

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/2/3/27

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Work Order ID 81394***81394***

March-14-12 7:46:33 AM

Page 7

Item ID: D350-636-011

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NS1

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Item Name: Skidtube LH

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Start Date: 13/03/2012 Start Qty: 1.00

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1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC: _____

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

190

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

1XPM/12/03/28

200

200

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1 Q @ 12/03/29

Memo

START TIME: 8h25
OVEN TEMPERATURE: 320°F
FINISH TIME: 8h55

m120 222

210

210

QC

Quality Control

QC/Inspect Chemical Conversion Coat

0.00

Memo

Inspect for foreign object per QSI 024

1XPM/12/04/03

P o w d e r

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 81394

March-14-12 7:46:33 AM

81394

Page 8

Item ID: D350-636-011

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N900040100

Setup

Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 13/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

220

220

HandFinish

Hand Finishing

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

XBM 12/04/03

230

230

HandFinish

Hand Finishing

HandFinishing

0.00

XBM 12/04/03

Memo

0.00

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 120318

EXP DATE: 12/08

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 12/08

5-Coat all exposed fasteners with "LPS Procyon" batch: M110348

5-Coat all exposed fasteners with "LPS Procyon" batch: M114596

Dart Aerospace Ltd

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Work Order ID 81394

March-14-12 7:46:33 AM

81394

Page 9

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N900040100

Setup

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NS1

Revision ID:

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NS2Start Date: 13/03/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240 QC5- Inspect part completeness to step on W/O

240

QC

Quality Control

0.00

S. Silverlog

250 Pick Kit 0.00

250

Packaging

Packaging

Memo

0.00

K SP 12-04-09

260 QC4- 100% Inspect kits for completeness 0.00

260

QC

Quality Control

Memo

0.00

*****ensure antiseize is on AN8C21A bolts*****

S. Silverlog

(H)

W/O:		WORK ORDER CHANGES					
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March-14-12 7:46:33 AM

Page 10

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Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

270

Packaging

Packaging

Packaging

Memo

0.00

280

280

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*DevZ**Pass 1/9 C**12/4/10**MF
12-04-09*

W/O:		WORK ORDER CHANGES					
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Picklist Print

March-14-12 7:46:36 AM

Work Order ID: 81394

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

81394
D350-636-011

Page 1
TB

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No		230	Each	130.0000	8	8	**		M/L 12/04/03	
---------	--	--------------	----	--	-----	------	----------	---	---	----	--	--------------	--

D3492-1	Plug	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
		FP002		130		
		69531		8		
		74444		2		
		76235		20		
		77037	✓	100		

D3492-3		Manufactured	No		230	Each	69.0000	8	8	**		8	
---------	--	--------------	----	--	-----	------	---------	---	---	----	--	---	--

D3492-3	Plug	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	
		FP-A		69		
		78600	69	1381967 X 8		

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March-14-12 7:46:36 AM

Page 2

Work Order ID: 81394

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased No

230 Each 209.0000 8 8

NAS1611-010

O-RING

121166 **

8 M/L 12/04/03

Location	Loc Qty	Loc Code
FP	50	
110915	0	
120770	50	
FP001	159	
110915	14	
117460	8	
118077	1	
118612	3	
119438	47	
120308	36	
120986	50	

NAS1149D0863J

Purchased No

250 Each 231.0000 2 2

NAS1149D0863J

WASHER

**

Sp 12-04-09

Location	Loc Qty	Loc Code
ST298	231	
118078	36	
119307	95	
120308	100	

D2744

Manufactured No

110 Each 60.0000 1 1

D2744

Cap

**

Ac 12/03/22

Location	Loc Qty	Loc Code
LG002	60	
62715	1	
70881	10	
71861	7	
78900	42	

W/O:		WORK ORDER CHANGES					
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March-14-12 7:46:36 AM

Page 3

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D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each

26.0000

1

1

**

(1)

GST-12-83-22

D2600-3-BENT

Extrusion Bent

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG	26	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	15	

D2743

Manufactured No

160 Each

248.0000

8

8

**

BE12/03/23

D2743

Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG001	248	
67766	4	
68251	3	
73403	64	
74445	1	
78603	76	
79517	100	

D2739

Manufactured No

160 Each

8.0000

1

1

**

D2739

350 I Beam

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG	8	
72155	1	
89082	7	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:36 AM

Page 4

Work Order ID: 81394

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

81394
D350-636-011

Start Date: 13/03/2012

Start Qty: 1.00

Required Date: 27/03/2012

Required Qty: 1.00

D3490-3

Manufactured

No

160

Each

38.0000

4

4

**

D3490-3

Cross Bolt Spacer

BE 12/03/23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	38	
78800	38	

D3490-1

Manufactured

No

160

Each

49.0000

4

4

**

D3490-1

Cross Bolt Spacer

BE 12/03/23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	49	
62450	2	
74875	4	
77042	3	
78793	40	

ALS4-1032-225

Purchased

No

220

Each

1,134.000

38

38

**

AI S4-1032-225

Insert

M/L 12/04/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	1021	
108696	146	
110768	62	
118386	55	
118966	68	
120671	690	
ST282	113	
120410	100	
120451	13	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:36 AM

Page 5

Work Order ID: 81394

81394
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

26.0000

1

1

**

D3793-3

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	12	
80434	12	
FP002	14	
78935✓	14	

m.k 12/04/03

AN8C35A

Purchased No

230

Each

65.0000

1

1

**

AN8C35A

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	64	
115960	1	
117834	10	
118286✓	53	
ST346	1	
114442	0	
115188	0	
115960	1	

m.k 12/04/03

D3793-1

Manufactured No

230

Each

18.0000

1

1

**

D3793-1

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	18	
77029✓	6	
78901	12	

m.k 12/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:37 AM

Page 6

Work Order ID: 81394**Parent Item:** D350-636-011**Parent Item Name:** Skidtube LH

81394
D350-636-011

Start Date: 13/03/2012**Start Qty:** 1.00**Required Date:** 27/03/2012**Required Qty:** 1.00

D3488-041

Manufactured No

230

Each

17.0000

1

1

**

D3488-041

Blade Fitting Assembly, LH

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	17	
61689	1	
75056 ✓	7	
77021	9	

m-l 12/04/03

D3794-3

Manufactured No

230

Each

31.0000

1

1

**

D3794-3

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	31	
74530	2	
78895	5	
80436 ✓	24	

m-l 12/04/03

AN6C44A

Purchased No

230

Each

107.0000

4

**

AN6C44A

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
103964	2	
ST343	105	
120095	12	
120143	25	
120465	27	
120641 ✓	21	
121013	20	

m-l 12/04/03

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:37 AM

Page 7

Work Order ID: 81394

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

81394
D350-636-011

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

85.0000

1

1

**

MS21083C8

NUT

m/l 12/04/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	1	
115884	1	
ST303	14	
115884	0	
118077	1	
119309	2	
119436 ✓	9	l
119638	2	
ST304	70	
120142	20	
120731	25	
121011	25	

D3536-25

Manufactured

No

230

Each

16.0000

1

1

**

D3536-25

Gasket

m/l 12/04/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	16	
78902 ✓	16	l

D3631-1

Manufactured

No

230

Each

223.0000

8

**

D3631-1

Washer

m/l 12/04/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST072	223	
68062 ✓	2	
75548 ✓	221	8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:37 AM

Page 8

Work Order ID: 81394

81394
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured

No

230

Each

17.0000

1

1

**

D3791-1

Wearplate

m-l 12/04/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	17	
62239	2	
75041	3	
78897 ✓	12	

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38

***AN960C10I ***

washer

D2745

Manufactured

No

230

Each

136.0000

8

8

m 118354 **

38 m 12/04/03 *

D2745

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	100	
79518 ✓	100	
FP001	36	
69529	1	
76142	1	
78597	34	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:37 AM

Page 9

Work Order ID: 81394

81394
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

998.0000

34

34

**

AN3C5A

Bolt

m/p 12/03/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	7	
115835	7	
ST350	991	
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423 ✓	918	

D3537-1

Manufactured

No

230

Each

151.0000

3

3

**

D3537-1

Wearpad

m/p 12/04/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	104	
79833 ✓	50	
79835 ✓	54	
FP002	47	
69817	5	
79834	42	

NAS1149C0832R

Purchased

No

230

Each

304.0000

1

1

**

NAS1149C0832R

WASHER

m/p 12/04/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	304	
114915 ✓	304	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:37 AM

Page 10

Work Order ID: 81394

81394
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

623.0000

4

4

**

AN3C6A

BOLT

M/L 12/04/03

Location	Loc Qty	Loc Code
FP001	1	
111982	1	
ST351	622	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	133	4
120693	400	

NAS1611-013

Purchased

No

230

Each

168.0000

8

8

**

NAS1611-013

O-RING

M/L 11/04/09

X/

Location	Loc Qty	Loc Code
FP001	168	
116582	5	
117291	2	
117887	53	
119623	36	
120360	22	
120910	50	X/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:37 AM

Page 11

Work Order ID: 81394

81394
D350-636-011

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

19.0000

1

1

**

D3535-25

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	14	
62233 ✓	1	
80331 ✓	13	
FP002	5	
77617	5	

m/l 12/04/03

D3794-1

Manufactured No

230

Each

24.0000

1

1

**

D3794-1

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	24	
75042 ✓	12	
80435	12	

m/l 12/04/03

MS21043-6

Purchased No

230

Each

809.0000

4

**

MS21043-6

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
103693 ✓	20	
ST301	789	
112314 ✓	83	
117887	6	
118384	200	
120308	500	

m/l 12/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:37 AM

Page 12

Work Order ID: 81394

81394

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured

No

250

Each

66.0000

2

2

**

SQ

D3493-1

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST050

66

70697

2

77573

24

78835

40

MS2108C8

Purchased

No

250

Each

85.0000

2

2

**

SQ

MS2108C8

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP002

1

115884

1

ST303

14

115884

0

118077

1

119309

2

119436

9

119638

2

ST304

70

120142

20

120731

25

121011

25

Purchased

No

250

Each

51.0000

2

2

**

SQ 12-04-09

AN8C21A

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST343

51

118758

5

120094

42

120872

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 7:46:37 AM

Page 13

Work Order ID: 81394

81394

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased No

230 Each

184.0000 4 4

**

*NAS1515H3L *

WASHER

M-12/04/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
102472	40	
ST277	144	
118686	3	
119438	1	
120072 ✓	40	4
120360	100	

D2741

Manufactured No

250 Each

37.0000 1 1

**

D2741

Blade, 350 Skidtube

SP

12-04-09

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	-10	
ST466	47	
71856	1	
76984	36	

D3532-1

Manufactured No

250 Each

39.0000 2 2

**

D3532-1

Spacer

SP

12-04-09

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST053	39	
78839	39	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1				D3488-041	BLADE FITTING, LH
1			1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4			4	D3490-3	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL 
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL 

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NO. 81394 MLJ
12/03/14

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6-29-12 14

F	INCORPORATE DS1 9413 QTY (3) D3536-25 (N8-1) D3791-1; REMOVE D3535-13/35 (Z8-1); D3794-1/3 REPLACES D3535-13/35 (Z8-1); ADD D3791-1 (Z8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (Z8 B8-1); D3488-041/-042 HARDWARE UPDATED (Z8 C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (Z8 A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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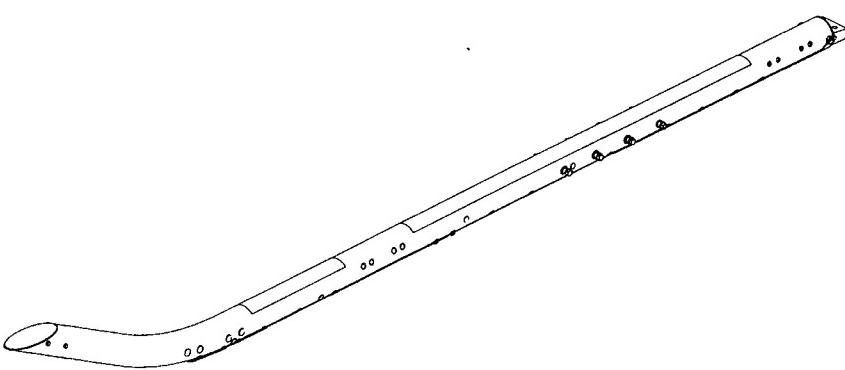
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

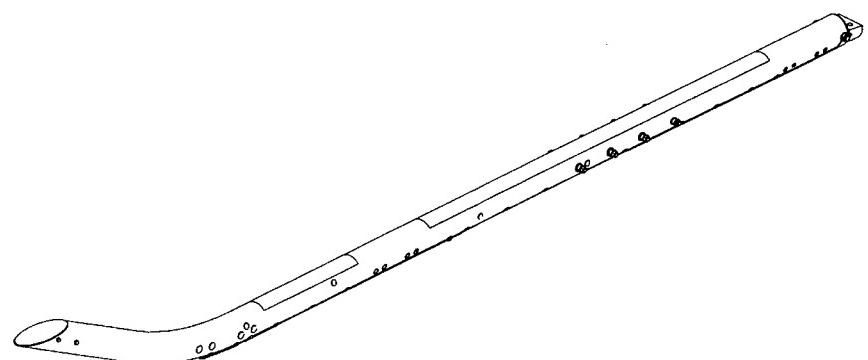
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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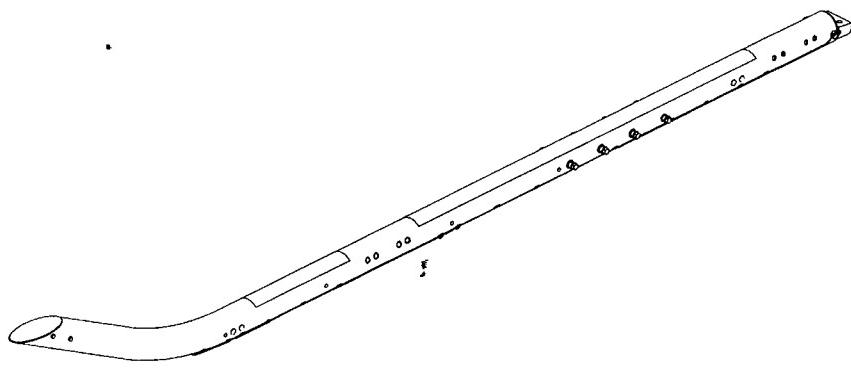
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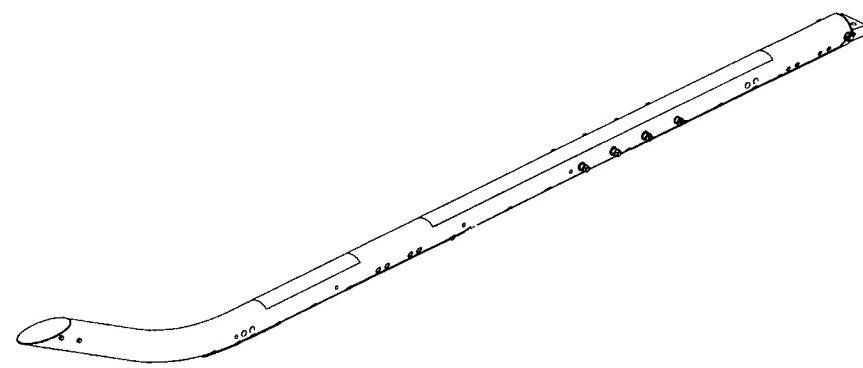
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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81394



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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MFG. APPR.	<i>JK</i>	D2750	SHEET 3 OF 11
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DE APPR.	<i>JK</i>	350 SKIDTUBE ASSEMBLY	NTS
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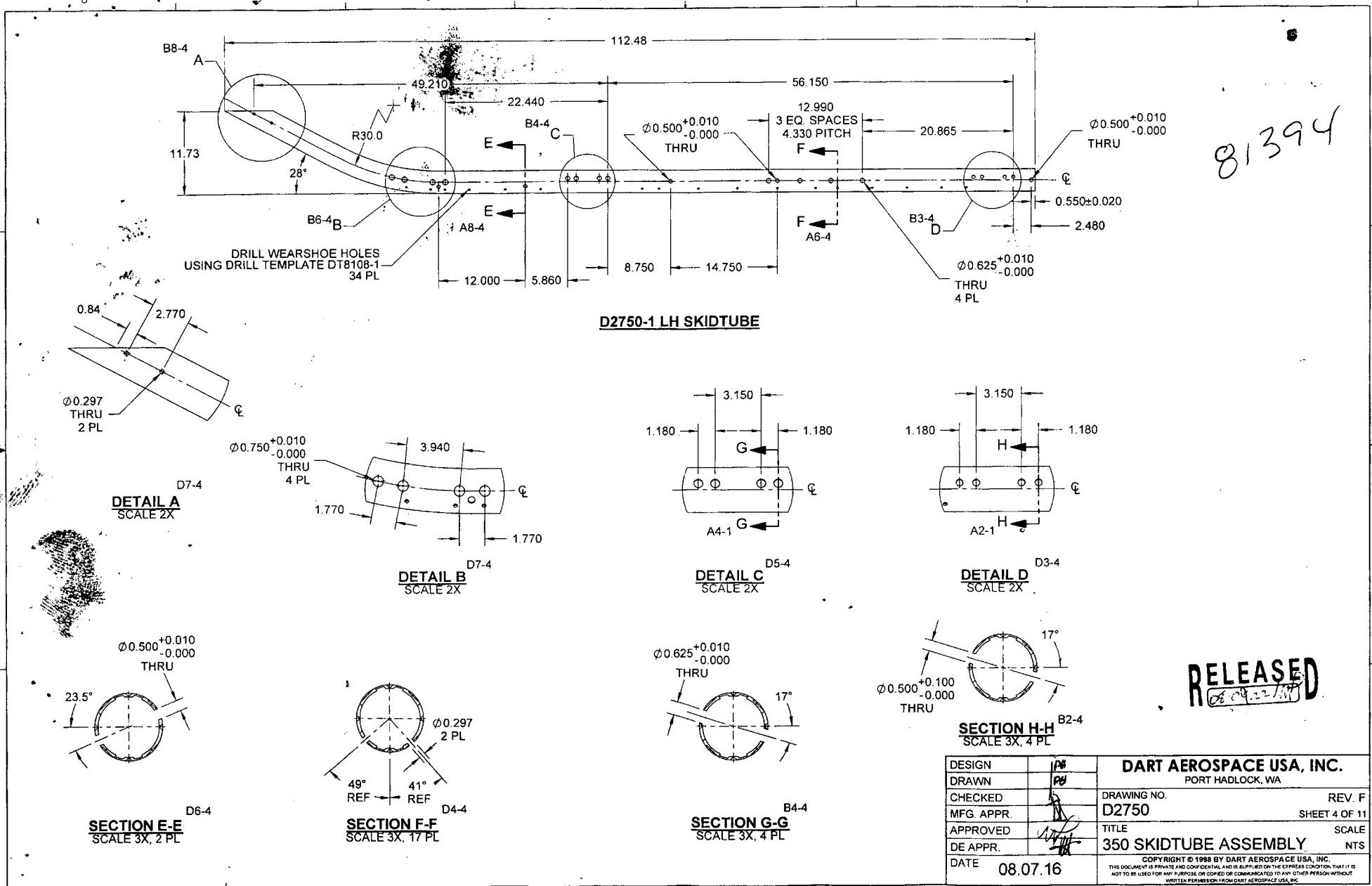
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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APPROVED	1D	TITLE	350 SKIDTUBE ASSEMBLY NTS
DE APPR.		DATE	08.07.16

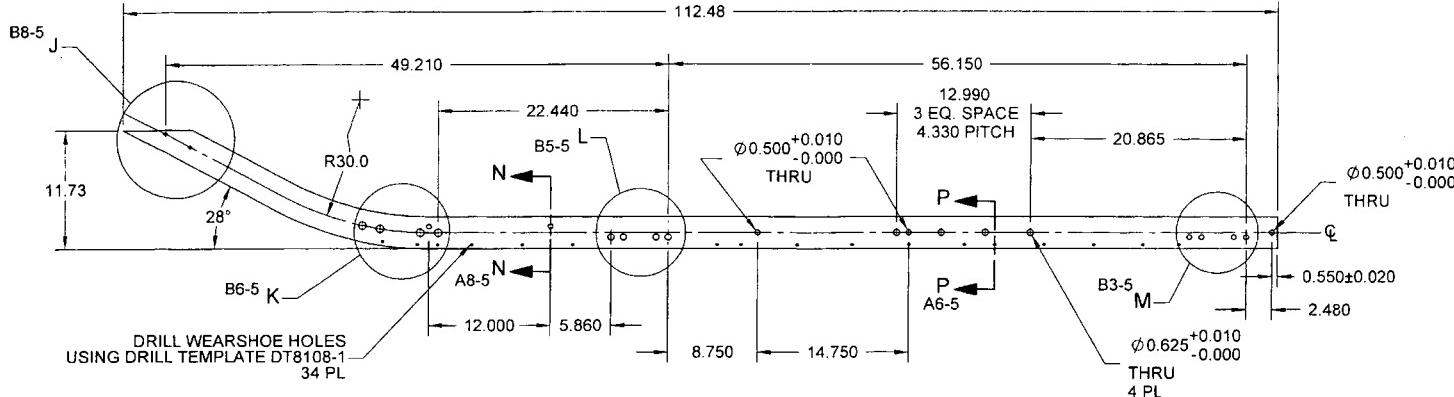
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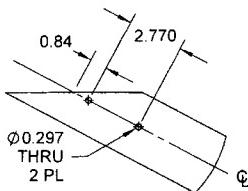
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

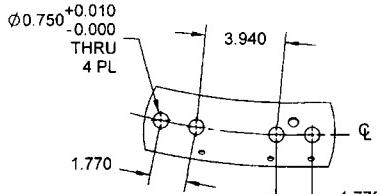
NOTE: Date & initial all entries



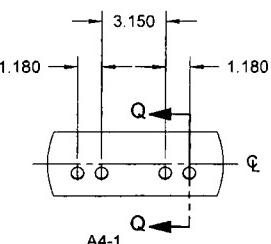
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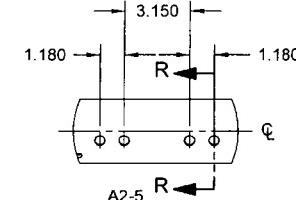
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SCALE 2X



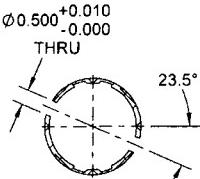
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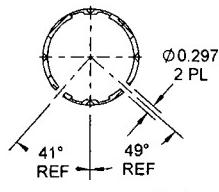
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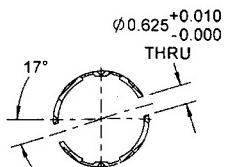
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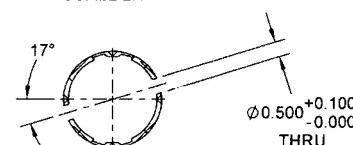
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R
SCALE 3X, 4 PL

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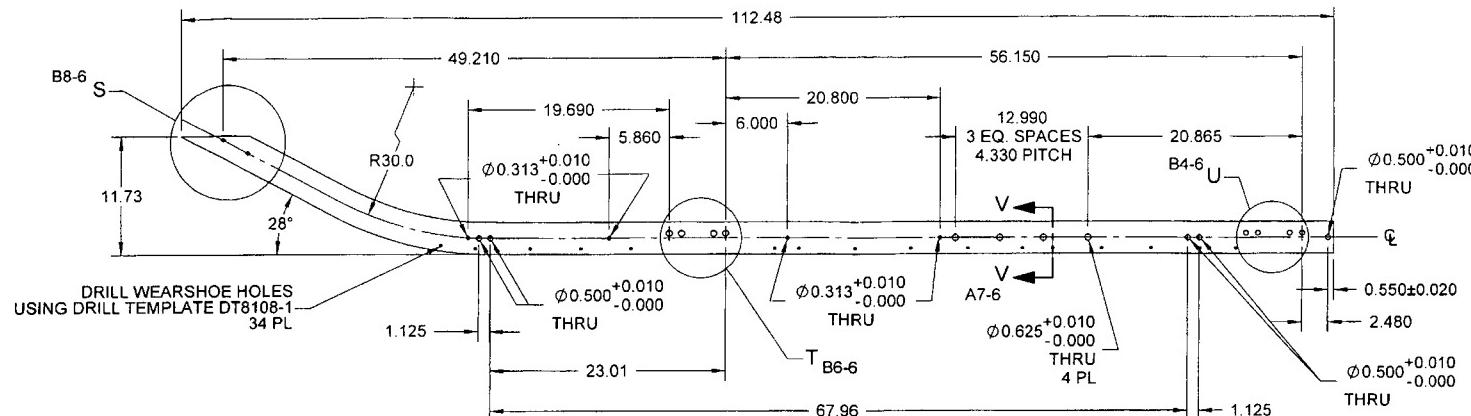
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DRAWN	P1	DRAWING NO. D2750
CHECKED		REV. F SHEET 5 OF 11
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY
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DE APPR.		
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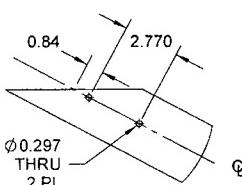
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

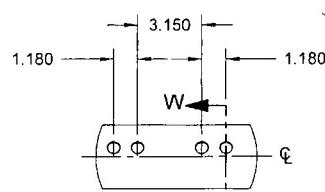


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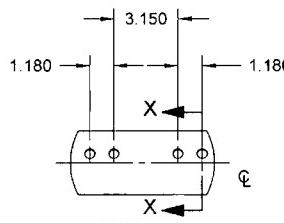
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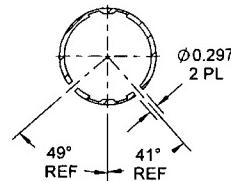
D8-6



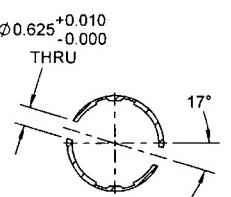
C5-6



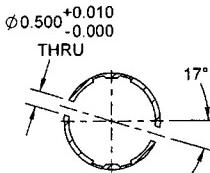
D3-6



C443
SECTION V-V
SCALE 3X, 17 PL



B6-6



SECTION X-X
SCALE 3' 4 RI

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC.		
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F	
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 6 OF 11	
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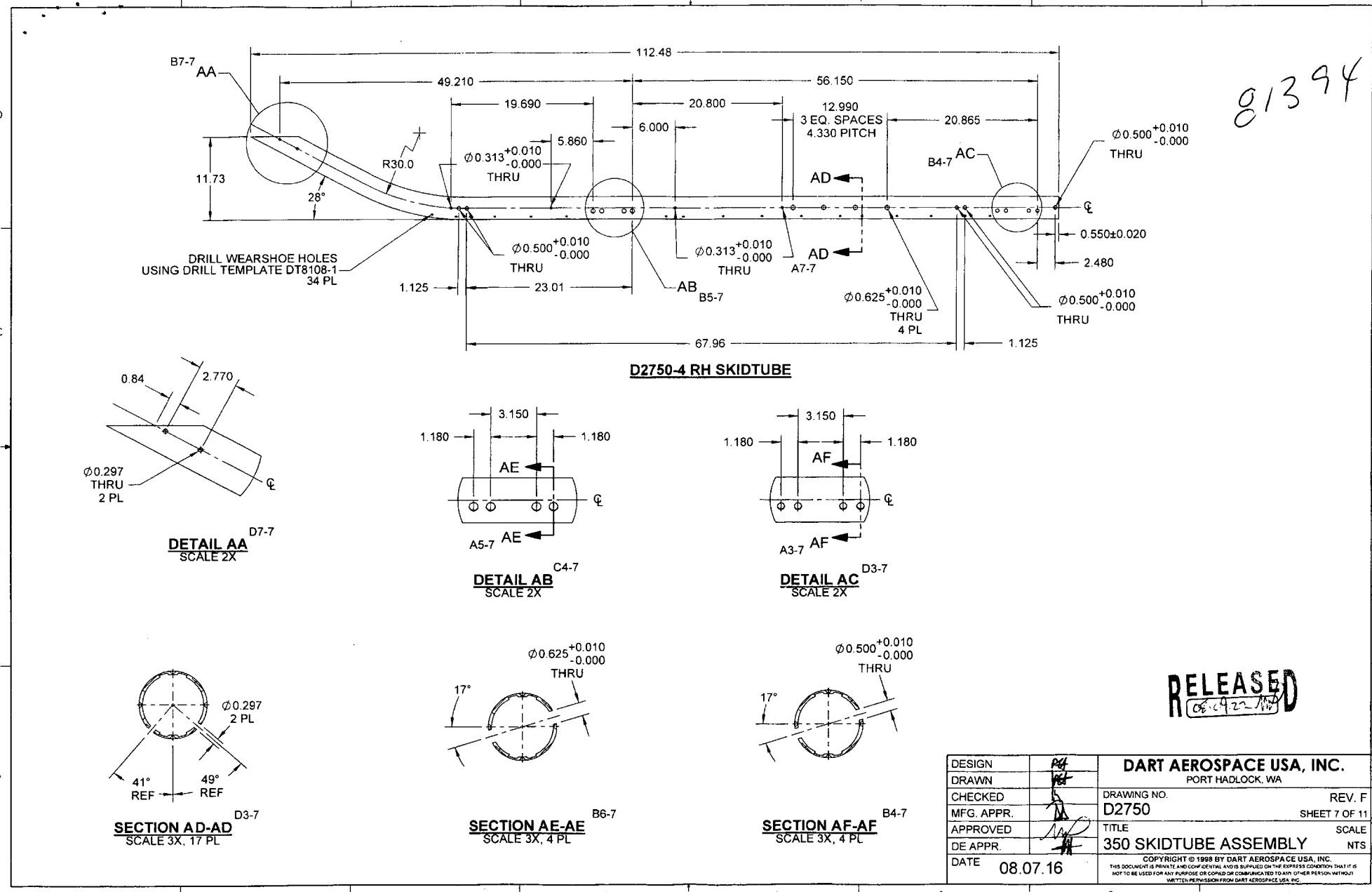
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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8/13/94

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CHECKED	S	DRAWING NO.	REV. F	
MFG. APPR.	M	D2750	SHEET 7 OF 11	
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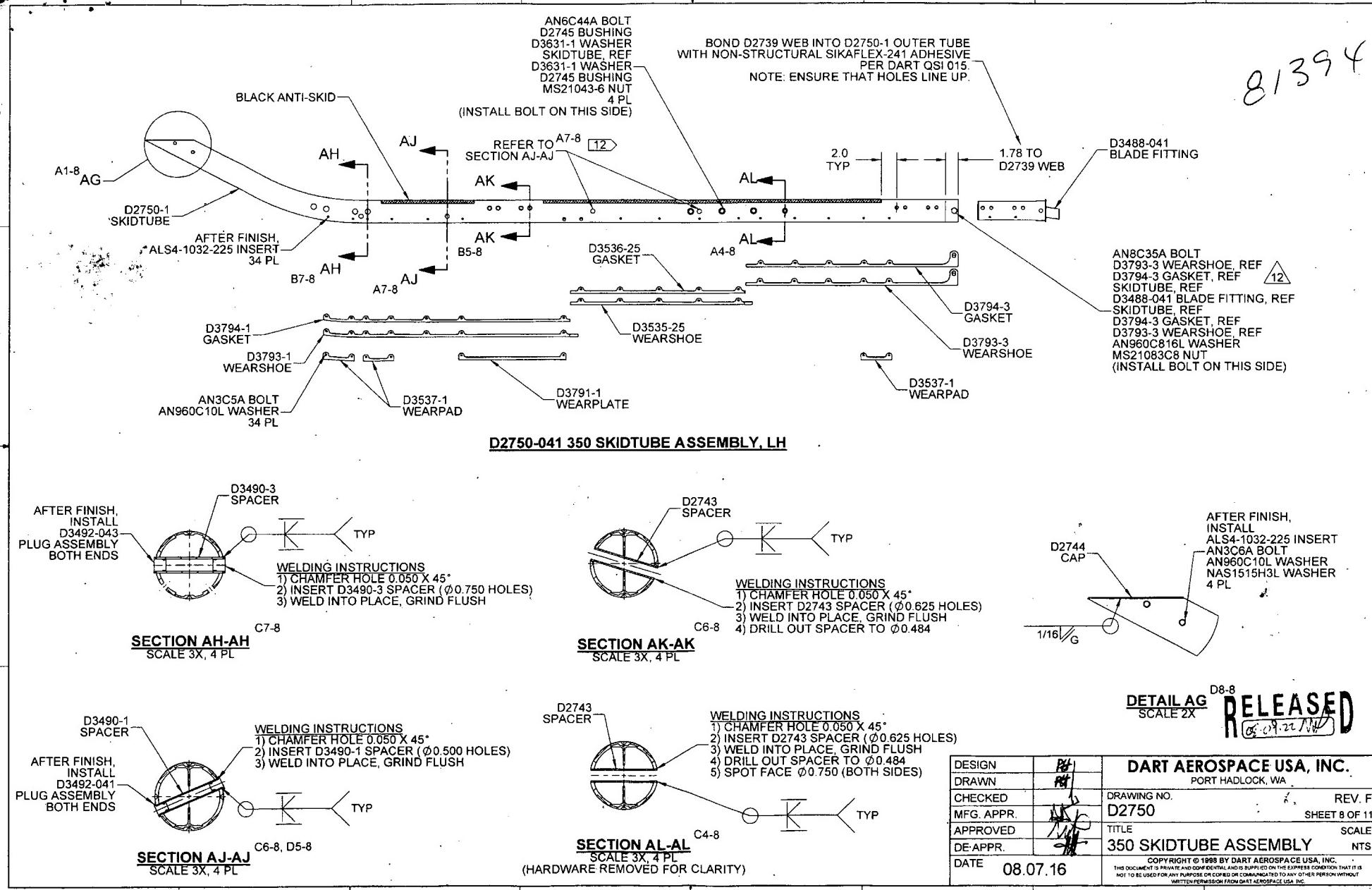
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DRAWN	P&I	PORT HADLOCK, WA		
CHECKED	AK	DRAWING NO.	REV. F	
MFG. APPR.	AK	D2750	SHEET 8 OF 11	
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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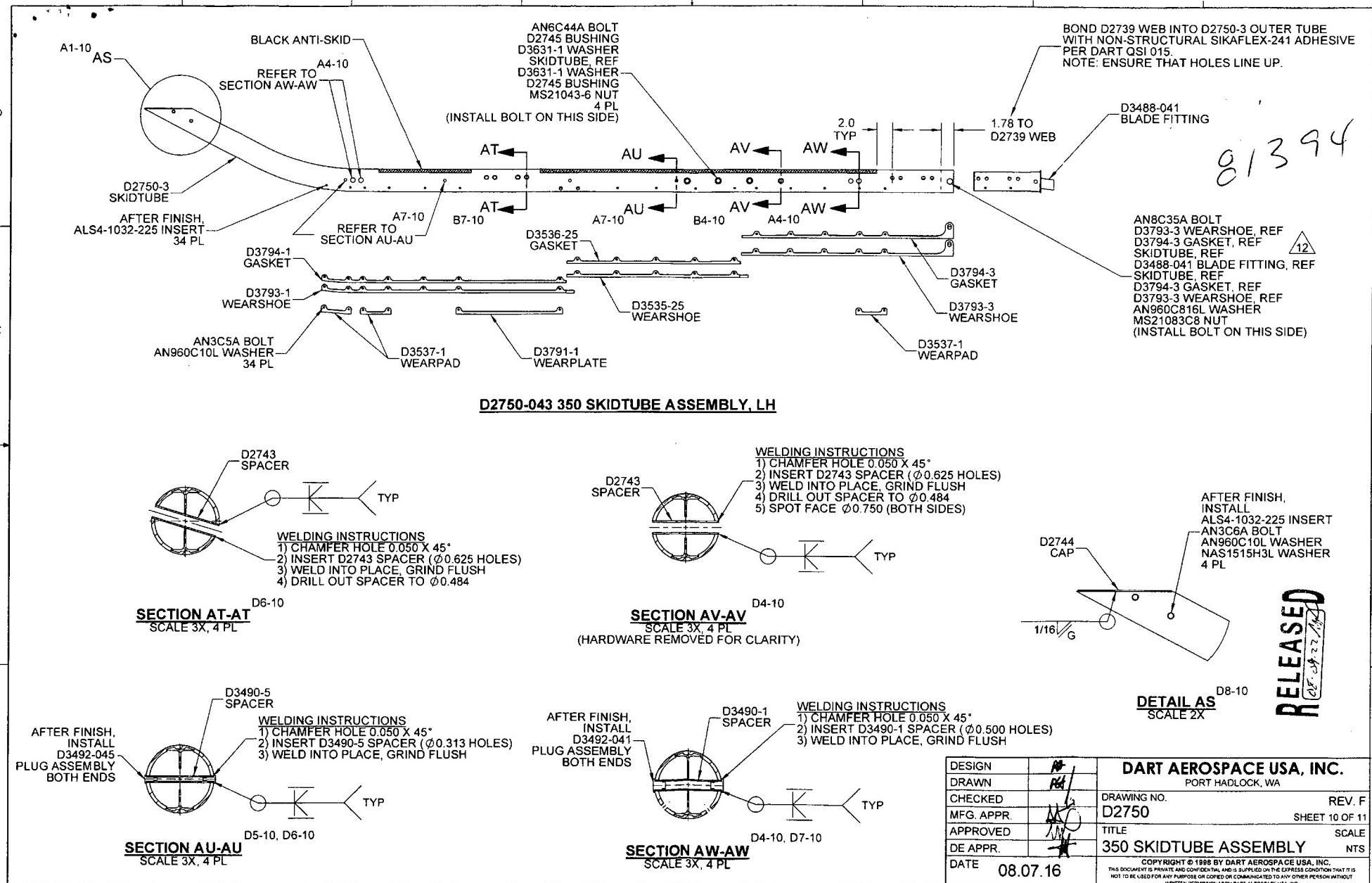
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DRAWN	P&H	PORT HADLOCK, WA
CHECKED		
MFG. APPR.	APC	DRAWING NO. D2750
APPROVED	TM	REV. F SHEET 10 OF 11
DE APPR.	X	TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

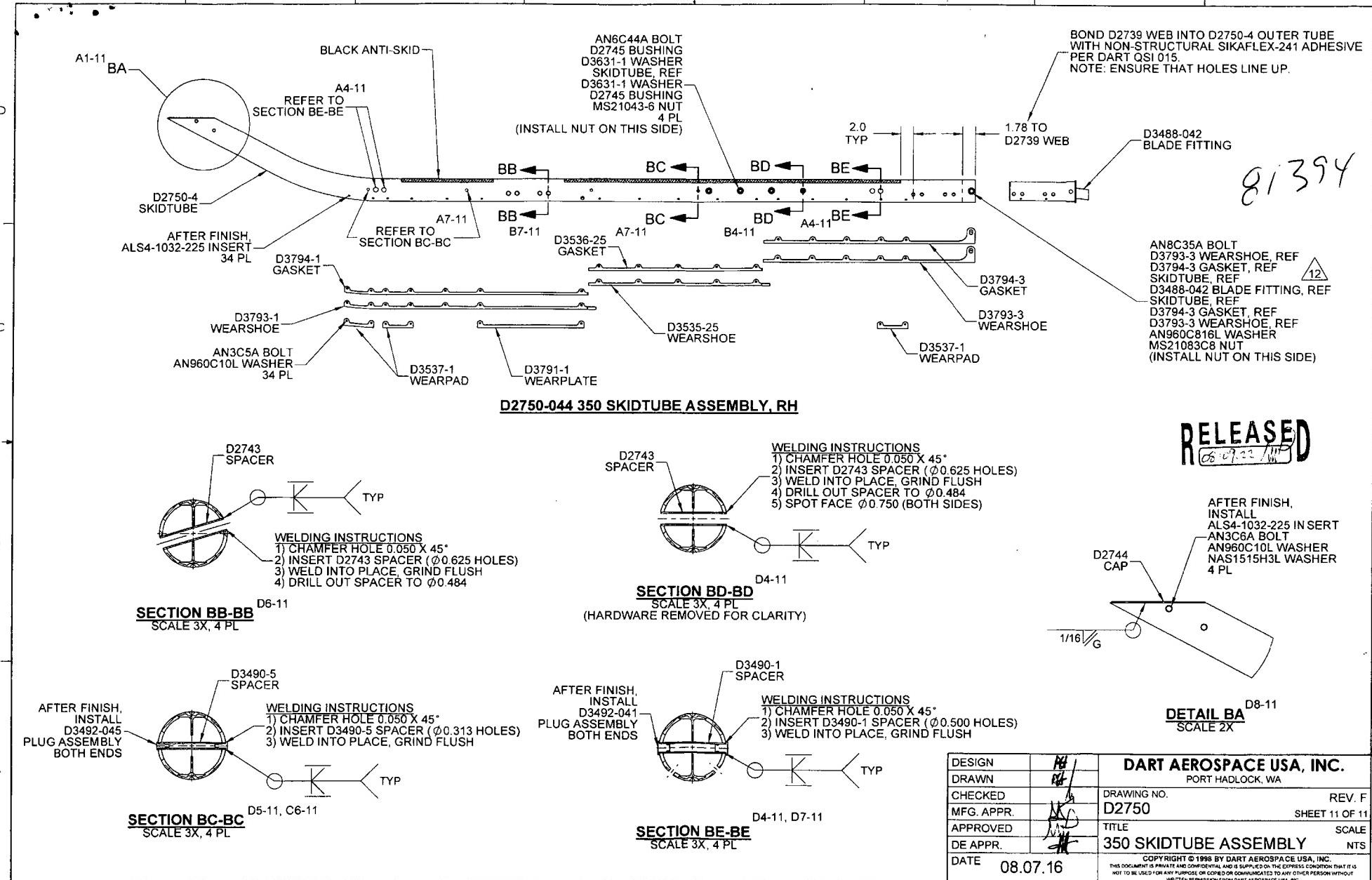
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN	<u>AS</u>	DART AEROSPACE USA, INC.		
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MFG. APPR.	<u>AS</u>	DA7250	SHEET 11 OF 11	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 282

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 78413
Part number: A350-636-011
Description: Skid tube
Welding Process: Tig[] Mig[]
Base materiel: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap) pass[] fail[]
Porosity (surface): pass[] fail[]
Coloration: pass[] fail[]

Qualifier David Newell Date of Test Coupon 12.02.01
Welder Barclay Elliott Date of Test Coupon 12.02.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld